

Split

Dart Aerospace Ltd.

Date: Tuesday, 08/01/2008 3:19:44 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 03.250 SUPPORT
Job Number	: 35582 -3	Part Number	: D29401
Estimate Number	: 10387	Drawing Number	: D2940 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 08/01/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 06/11/2007 Type : MACHINED PARTS	Due Date	: 13/12/2007
Previous Run	: 35478	Qty:	20 Um: Eac
Written By	: <i>[Signature]</i>		
Checked & Approved By	:		
Comment	: Est. C 02.11.26 Reformat; Added P/O KJ Est Rev:D Added priming as per Rev B 07-04-30 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6104007	17-4 SS Roundbar 4.50"OD
Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) 17-4 SS Roundbar 4.50"OD 35478 D6104-007 BATCH: 35582A <i>RC 08/01/09</i>		
2.0	35582A	ROUND BILLET 17-4
Comment: Sub-Component ROUND BILLET 17-4 D6104-007 B <i>N/A</i>		
3.0	DOOSAN LATHE	DOOSAN LATHE
Comment: Doosan Turn blank for Haas as per Folio FA079 <i>RC 08/01/09</i>		
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET <i>RC 08/05/18</i>		
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS 1- Machine as per Folio FA079 2- Tumble & Deburr <i>7m/L 08/04/15</i>		

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 35582

Part Number: D29401

Job Number:



30min

16/04/2008

S.033

#1 407.2

#2 D29401

#3 B35582

#4

Seq. #:	Machine Or Operation:	Description :
6.0	QC1	INSPECT ALL DIM TO DIM SHEET
Comment: INSPECT ALL DIM TO DIM SHEET		FL / 124/3L 08/04/15
7.0	QC8	SECOND CHECK
Comment: SECOND CHECK		25 08/04/15 (4)
8.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 *****Mask Inside Surface as per Dwg D2940*****		m/07550 FL 08/04/16 (4)
9.0	SPRAY PAINTING	SPRAY PAINTING
Comment: SPRAY PAINTING Prime inside surface as per Dwg D2940 and QSI 005 4.3.		ml 08 04 18 (8)
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		08-04-22
11.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LE		ml 08 04 22 (8)
12.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		08/04/23 (4)
Job Completion		mf 08-04-22

AEROSPACE LTD		Work Order: 35582
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. D7 D00000				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		0.726	0.726	0.724	0.724		
D	0.090	0.110		0.102	0.102	0.102	0.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		0.03	0.03	0.03	0.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		0.122	0.122	0.122	0.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		0.423	0.423	0.423	0.423		
L	0.913	0.933		0.923	0.923	0.923	0.923		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.150	0.150	0.150	0.150		
AD	3.510	3.530		3.514	3.525	3.525	3.525		
AE	1.633	1.673		1.642	1.650	1.650	1.650		
AF	1.493	1.513		1.502	1.502	1.500	1.500		
AG	0.040	0.060		0.051	0.050	0.050	0.050		
AH	0.188	0.193		0.188	0.188	0.188	0.188		
AI	0.140	0.160		0.148	0.153	0.153	0.153		
AJ	2.518	2.538		2.530	2.530	2.530	2.530		
AK	0.040	0.060		0.051	0.051	0.050	0.050		
AL	0.010	0.020		0.015	0.015	0.015	0.015		
AM	0.140	0.160		0.154	0.154	0.152	0.152		
AN	0.350	0.450		0.355	0.355	0.350	0.350		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.150	0.154	0.150	0.150		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64		103.64	103.60	103.60	103.60		
AS	0.260	0.267		0.260	0.266	0.266	0.266		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.123	4.126	4.126	4.126		
AV									

Accept/Reject

Measured by: [Signature]	Audited by: [Signature]
Date: 01/11/18	Date: [Signature]

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM [Signature]	[Signature]

Description: Ø3.250 Support

Part Number: D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.950	4.950	4.950	4.950		
C	0.718	0.738		0.725	0.725	0.725	0.725		
D	0.090	0.110		0.090	0.090	0.090	0.090		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		0.02	0.02	0.02	0.02		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		0.12	0.12	0.12	0.12		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.46	4.46	4.46	4.46		
K	0.413	0.433		0.42	0.42	0.42	0.42		
L	0.913	0.933		0.92	0.92	0.92	0.92		
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
Accept/Reject									

Measured by: KJ

Date: 02/12/12

Audited by:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	EE

AEROSPACE LTD

Work Order:

35582

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/9	12/10	8/11	4/12	By	Date
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.722	.724	.725	.727		
D	0.090	0.110		.102	.102	.103	.102		
E	3.564	3.584		3.577	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.152	.151	.151	.151		
AD	3.510	3.530		3.522	3.522	3.524	3.523		
AE	1.633	1.673		1.651	1.659	1.656	1.655		
AF	1.493	1.513		1.506	1.504	1.502	1.498		
AG	0.040	0.060		.050	.053	.050	.051		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.152	.153	.146	.147		
AJ	2.518	2.538		2.530	2.530	2.536	2.530		
AK	0.040	0.060		.050	.051	.050	.049		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.147	.148	.148	.148		
AN	0.350	0.450		.360	.360	.360	.360		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.158	.155	.157	.156		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.260	.260	.260		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.124	4.124	4.127	4.127		
AV									
Accept/Reject									

Measured by:

Date:

R. J. L. / J. L. / J. L.

Audited by:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	

AEROSPACE LTD

Work Order:

37582

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	113	214	315	416		
Lathe Section									
A	3.211	3.216							
B	4.946	4.966		4.956	4.982	4.956	5.056		
C	0.718	0.738		.724	.72	.727	.728		
D	0.090	0.110		.102	.102	.102	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.01	.01	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.186	2.186	2.186	2.186		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.506	.500	.500	.500		
AC	0.140	0.160		.150	.149	.150	.151		
AD	3.510	3.530		3.525	3.525	3.527	3.525		
AE	1.633	1.673		1.655	1.657	1.657	1.655		
AF	1.493	1.513		1.497	1.500	1.497	1.498		
AG	0.040	0.060		.050	.050	.050	.050		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.148	.145	.146	.146		
AJ	2.518	2.538		2.528	2.527	2.528	2.528		
AK	0.040	0.060		.049	.050	.049	.052		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.146	.147	.146	.146		
AN	0.350	0.450		.360	.360	.360	.366		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.158	.158	.166	.158		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.261	.260	.260		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.128	4.128	4.128	4.128		
AV									

Accept/Reject

Measured by:

Date:

6/3/2012 08/04/12

Audited by:

Date:

25 08/04/24

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	EE

AT AEROSPACE LTD		Work Order: 35582
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

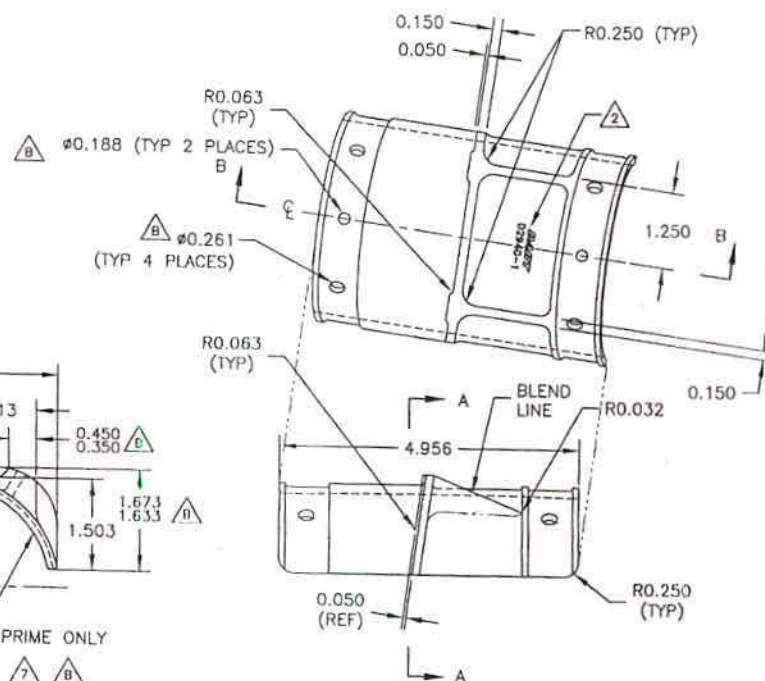
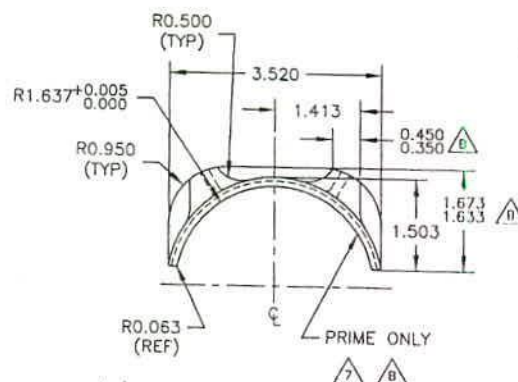
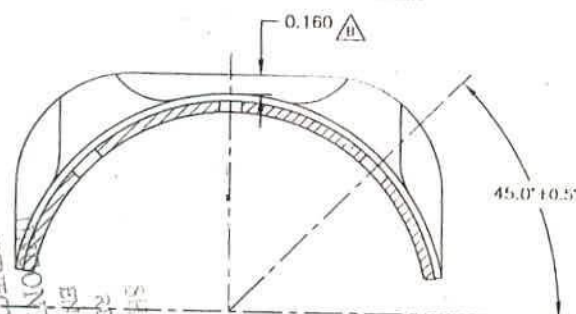
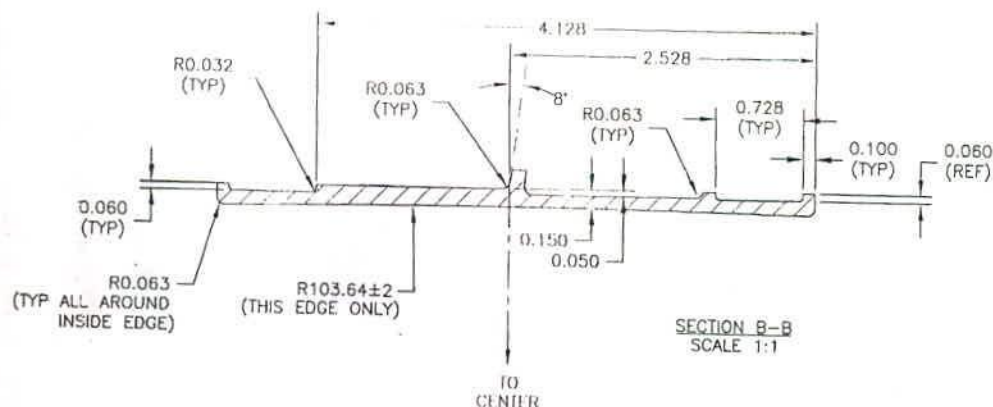
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	17	18	19	20		
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.955	4.954	4.954	4.954		
C	0.718	0.738		0.728	0.728	0.728	0.728		
D	0.090	0.110		0.102	0.102	0.102	0.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		0.03	0.03	0.03	0.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		0.122	0.122	0.122	0.122		
I	2.170	2.190		2.181	2.181	2.181	2.181		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		0.423	0.423	0.423	0.423		
L	0.913	0.933		0.923	0.923	0.923	0.923		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.160	0.160	0.152	0.153		
AD	3.510	3.530		3.520	3.520	3.520	3.520		
AE	1.633	1.673		1.658	1.663	1.652	1.652		
AF	1.493	1.513		1.502	1.508	1.499	1.503		
AG	0.040	0.060		0.050	0.050	0.050	0.051		
AH	0.188	0.193		0.188	0.188	0.188	0.188		
AI	0.140	0.160		0.152	0.149	0.150	0.151		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.050	0.050	0.050	0.050		
AL	0.010	0.020		0.011	0.011	0.011	0.011		
AM	0.140	0.160		0.155	0.155	0.151	0.151		
AN	0.350	0.450		0.425	0.425	0.425	0.425		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.155	0.160	0.153	0.153		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		0.260	0.260	0.260	0.260		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138		4.130	4.130	4.129	4.128		
AV									
Accept/Reject									

Accept/Reject

Measured by: <i>BC</i>	Audited by: <i>JS</i>
Date: <i>03/07/18</i>	Date: <i>08/04/15</i>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	<i>BE</i>

RELEASED
(67-4-24 (P))
PER ECN 181



NO. 35588
WORK CENTER
SUBJECT TO ANY NEW
CONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

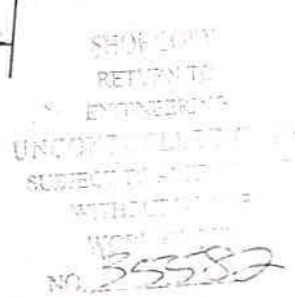
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DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	GP	DRAWN BY PH
CHECKED	th	APPROVED
DATE	07.03.16	DRAWING NO. D2940
		TITLE Ø3.250 SUPPORT
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		REV. B
		SHEET 1 OF 1
		SCALE 1:2

~~Shree Lal~~

03 07 01 4



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